

Specific application

Edge and face gluing

This process involves gluing solid or composite stock timber, either edge to edge, face to face or edge to face. Joint preparation is of critical importance since often, no other fasteners are used. The joints should fit tightly, squarely and be free of saw marks, knife marks, glazing or burnishing. On wide edge glued panels, care should be exercised in relation to the annular ring alignment pattern of the component parts to minimize warping and cupping of the panel.

Recommended products: *Titebond Original, Titebond Regular, Titebond 50, Titebond Supreme, Titebond II Premium and Titebond III Ultimate.*

Assembly gluing

The gluing of mortise and tenon, dovetail, tongue and groove, corner block, dowel, biscuit, mitre, cleat and many other types of joints can be classified as assembly gluing. Many types of assembly joints involve the gluing of long grain to long grain and long grain to end grain. Joint preparation is important as with other types of gluing. Joints should be cut accurately with sharp tools and fit tightly when clamped or assembled, as assembly glues are not designed to fill gaps.

Recommended products: *Titebond Original, Titebond Regular, Titebond 50, Titebond Supreme, Titebond II Premium (Weather-proof), Titebond III Ultimate (for high water resistance) and Titebond Polyurethane.*

Radio frequency gluing

RF gluing is similar in concept to hot pressing, in that heat is used to accelerate the curing process. The heat that helps dry the glue line is supplied by electrical energy (similar to microwave energy), but unlike hot press, the process can be used on materials of many different shapes. Cross-linking polymer glues like *Titebond II Premium* and *Multibond EZ-2* are required for successful radio frequency curing, and provide the additional benefit of *HPVA Type II* water-resistance.

Recommended products: *Titebond II Premium, Multibond EZ-2, Multibond X-016.*

General application tips

Joint preparation

Our glues work by penetrating the pores of the wood in a well formed joint to develop a bond stronger than the wood itself.

For this to occur, the surfaces to be bonded must be free of knife marks, saw marks, glazing, burnishing or any foreign materials that would tend to seal the pores of the bonding surface. Although the glues have some gap-filling ability, they are not designed to fill significant gaps.

As a rule, the strongest glue joints result from tight-fitting, well-machined and square joints. Dull cutting tools can result in burnished or glazed joints, or fuzzy surfaces containing a lot of short, torn wood fibres. All of these conditions can produce poor joints.

Assembly joints that fit so tightly that they must be hammered together can also be a cause for concern. The glue can be scraped away from the bonding surface as the joint is forced together.

Clean up

With proper application and tight-fitting joints there is still a potential for glue squeeze-out. This can be removed with a damp cloth while still in the wet stage, but excessive rubbing can cause a diluted film of glue to penetrate the surface, possibly causing problems in the finishing process. Use of a scraper to remove the excess can avoid the glue spot problems in the finishing process.

All of the products that we recommend for edge, face and assembly gluing are very sandable. The dried films of these products are very heat resistant and will not clog sanding belts or melt during the sanding process. This eliminates problems in the finishing process. The dried films of all the products are also non-abrasive and will not damage cutting tools.

Special care should be exercised in the clean up of water-resistant glues, such as *Titebond II Premium* and *Titebond III*, from clothing and other surfaces, as the dried films are very difficult to remove.

Note: *The use of a release agent on machine metal parts prior to gluing will result in easy removal of dried adhesive build-up.*



The Titebond story

In 1986 John Pfitzner discovered the Titebond product at an Atlanta machine fair. He began importing 44-gallon drums of Titebond Regular from Franklin International for his own use and one other local manufacturer, and Woodbond Adhesives was formed. By reputation alone, the business has grown from one tonne per year to now over 100 tonnes, with a much larger product range.

But the Titebond story begins more than 60 years earlier. Franklin has been the industry leader in bonding wood and wood products. Their history of innovation started in 1935 with Liquid Hide Glue, a ready-to-use formula that revolutionised the woodworking industry. In 1955, Franklin again set the standard with the development of the first aliphatic resin glue, *Titebond Original Wood Glue*. And then in 1991 introduced *Titebond II Premium Wood Glue*, the first one-part Type II water-resistant glue. Franklin's long-standing commitment to research and development continues to bring new and innovative products to the market.

Woodbond Adhesives now offer an expanded line of Titebond products which cater to the professional woodworker as well as the larger furniture and woodworking markets. These wood glues are at the leading edge of technology and we will continue to provide innovative products to meet the needs of the Australian woodworking market.



Titebond® Glues & Adhesives



Distributors

Vic/Tas	(03) 9706 6656	Timbalac
Qld	(07) 5564 6434	Timbalac
NSW	(02) 4268 6709	Woodbond (NSW)
SA	(08) 8326 3766	Abrasives Belts & Buffs
WA	(08) 9274 6566	S&S Industries

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